








Work Order ID **56725**

March 5, 2010 9:59:52 AM




Page 1

Item ID: D3391-011 Accept  Setup Start 
 Revision ID:
 Item Name: Fwd Tube Assembly Stop 
 Start Date: 05/03/2010 Start Qty: 1.00  Cust Item ID:
 Required Date: 17/03/2010 Req'd Qty: 1.00  Customer:
 Reference:


Approvals: Process Plan: RL Date: 10-3-05 Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3391 | Rev H |

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 100 |  Skidtubes | 0.00 | | | | | | | |
| | Skidtubes | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | Cut extrusion to 46.52 +0.010 -0.020 | | | | | | | | |

W 10/3/9

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 110 |  BENDING MACHINE - SKIDTUBES | 0.00 | | | | | | | |
| | CNC Bend 1 | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | Bend as per Dwg D3391 | | | | | | | | |

DP

10-3-10

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| | QC | | | | | | | | |
| | Memo | 0.00 | | | | | | | |
| | Quality Control | | | | | | | | |

h = 6.700"

202 12.70

S 10/03/10

40

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 56725

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Item ID: D3391-011

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Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

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Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA590 Rev. AA & Dwg D3391 Rev. H
Identify as D3391-1

2-Deburr

amf 10/03/27

1 0

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

amf 10/03/27

1 0

150

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Drill .1875" at end of tube as per Dwg D3391

amf 10/03/28

1 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*ml 10/03/28**1 0*

170



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

*S.F 10/03/31**1 0*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(DRILL ALL HOLES)

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr and scribe batch # inside aft end

7- transfer drill D3391-011 with D3391-013

11/10/4/6

11/12/4/5

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/4/6

(4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

1 M 10/4/6

210



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

1 BE 10/04/06

220



Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

1-Install crossbolt spacers per dwg D3391
A/R Magnabond 6398 batch: M112417

EX2 11/1/30

2- Grind flush

3- back drill crossbolt if necessary

M 10/4/6
) M 10/4/7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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Item ID: D3391-011

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Revision ID:

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Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sub 67

70

Re-alodine as per 09-043 ml 10-08-16 ①

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115291

Memo

0.00

START TIME: 8:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:30am

2) 10/08/17

1 9

250



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10 08 17 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Item ID: D3391-011

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Setup Start



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Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260



Packaging

Identify as per dwg & Stock Location: W/O 56719

0.00 mm

Memo

0.00

10-8-17

Packaging

270



Skidtubes

Skidtubes

0.00

⇒ M 10/08/17

Memo

0.00

x1 0

Skidtubes

**** install D3591-1 spacer as per DSI9364 ****

280



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/19 MF

Quality Control

MF
10-2-18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

March 5, 2010 9:59:50 AM

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Work Order ID: 56725



Parent Item: D3391-011



Parent Item Name: Fwd Tube Assembly

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP A 05.09.13 ☐ New issue ☐ KJ/JLM ☐
IPP B 06.02.09 ☐ Dwg rev.D EC ☐
IPP C 07.03.13 revF dwg ec
IPP D 07.11.01 ecn1053P EC

Start Qty: 1.00

Required Qty: 1.00

D6013-047



Manufactured No

220

Each

47.0000

1.0000



Skidtube Material

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

47

23935

3

26547

44

11/03/09

March 5, 2010 9:59:50 AM

Shop Packet Print

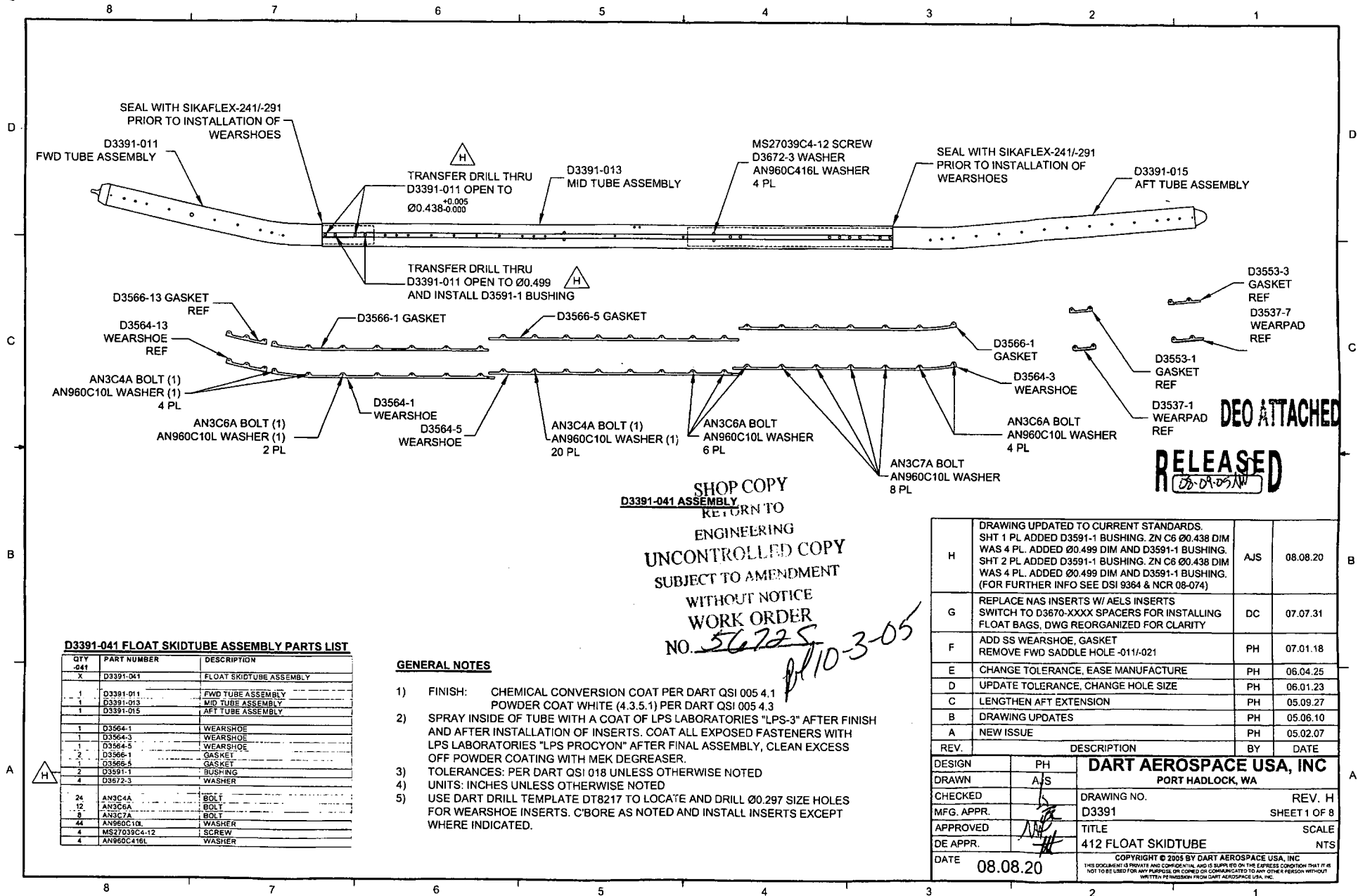
Page 114

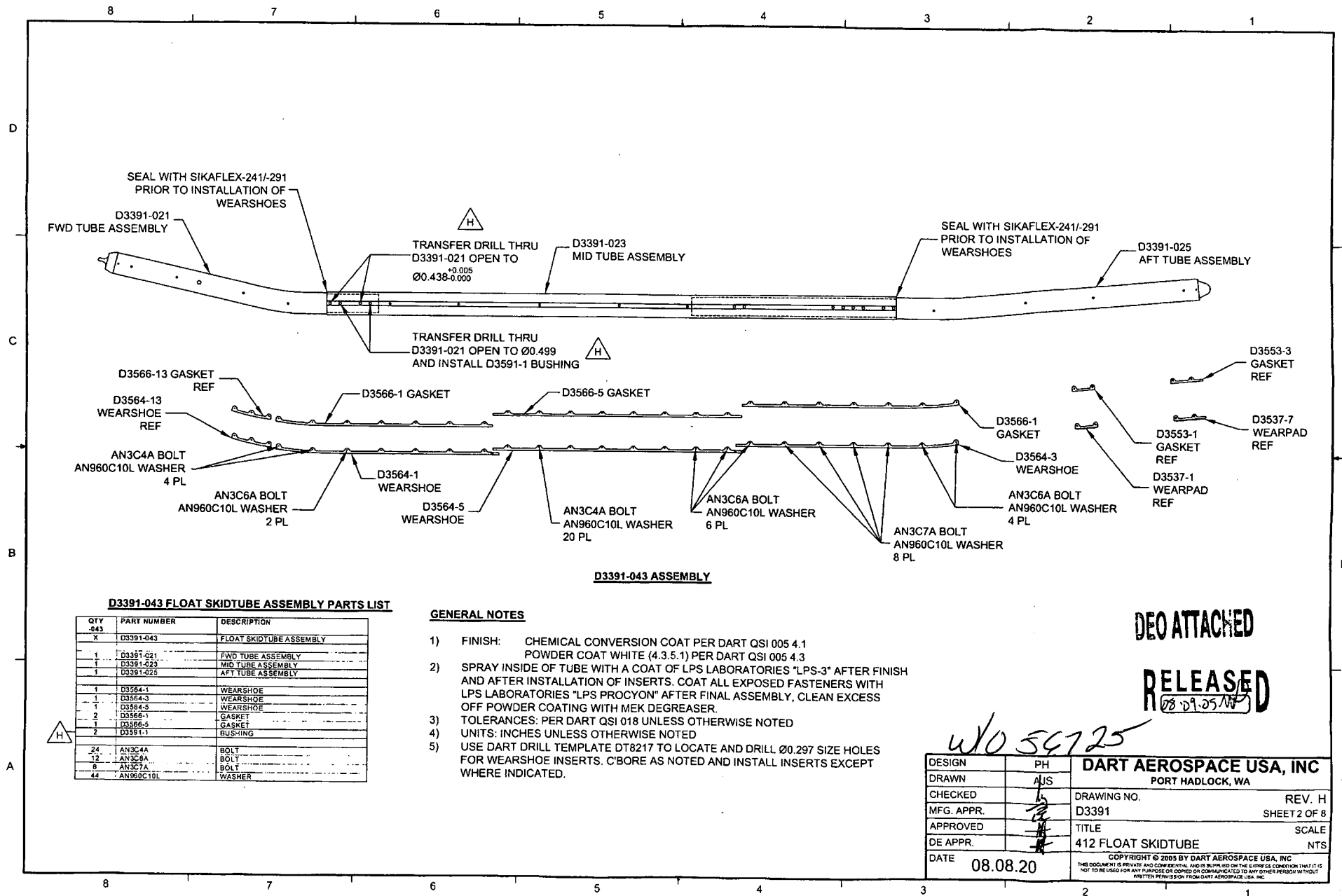
13391-011

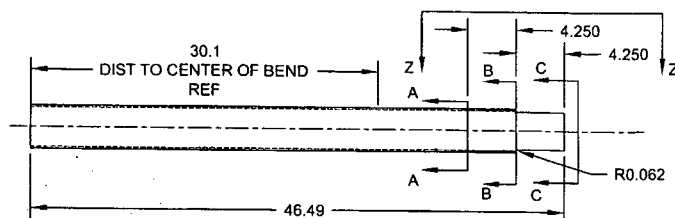
| Status | Item ID | Rev | Name | Start Date | Quantity | Pe | UOM | Scrap % | Route | Seq | IC | Sort | Comments | Date Last Mod | Add Date |
|--------|---------------|-----|-------------------|------------|----------|----|------|---------|-------|-----|----|------|----------|--------------------|--------------------|
| ✓ | D6013-047 | | Skidtube Material | 05/12/2009 | 1.0000 | | Each | 0 % | 100 | | | 1 | | 05/12/2009 7:18 PM | 05/12/2... |
| ✓ | D3401-041 | | Tow Cap Assembly | 07/04/2010 | 1.0000 | | Each | 0 % | 255 | | | 2 | | B50316 | 07/04/2... JJ |
| ✓ | D3564-13 | | Wearshoe | 07/04/2010 | 1.0000 | | Each | 0 % | 255 | | | 3 | x1 | B59660 | 07/04/2... JJ |
| ✓ | D3566-13 | | Gasket | 07/04/2010 | 1.0000 | | Each | 0 % | 255 | | | 4 | x1 | B59661 | 07/04/2... JJ |
| ✓ | D3670-4-200 | | SPACER | 07/04/2010 | 9.0000 | | Each | 0 % | 220 | | | 5 | | B48269 ⑨ | 07/04/2... m12/4/7 |
| ✓ | D3672-1 | | Phenolic Washer | 07/04/2010 | 4.0000 | | Each | 0 % | 255 | | | 6 | 4x | B52505 | 07/04/2... JJ |
| ✓ | AN3C4A | | BOLT | 07/04/2010 | 10.0000 | | Each | 0 % | 255 | | | 7 | 10x | M114941 | 07/04/2... JJ |
| ✓ | AN960C10L | | washer | 07/04/2010 | 10.0000 | | Each | 0 % | 255 | | | 8 | 10x | M115000 | 07/04/2... JJ |
| ✓ | AELS-1032-130 | 7 | NAS1149C0332R | 07/04/2010 | 2.0000 | | Each | 0 % | 255 | | | 9 | 2x | M11473 | 07/04/2... JJ |
| ✓ | AELS-1032-225 | | INSERT | 07/04/2010 | 10.0000 | | Each | 0 % | 255 | | | 10 | 10x | M110768 | 07/04/2... JJ |

penm. change AS 10.04.07

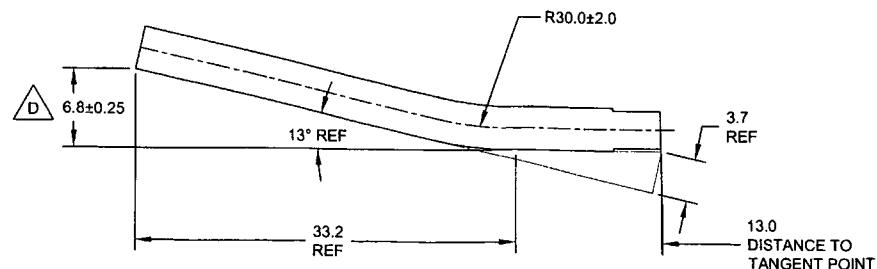
(All) 10/08/17



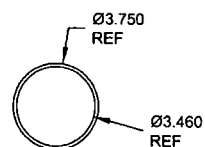




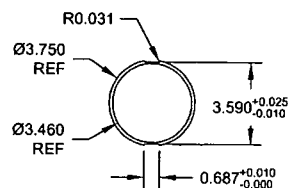
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



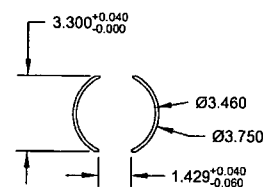
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



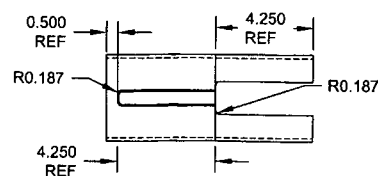
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

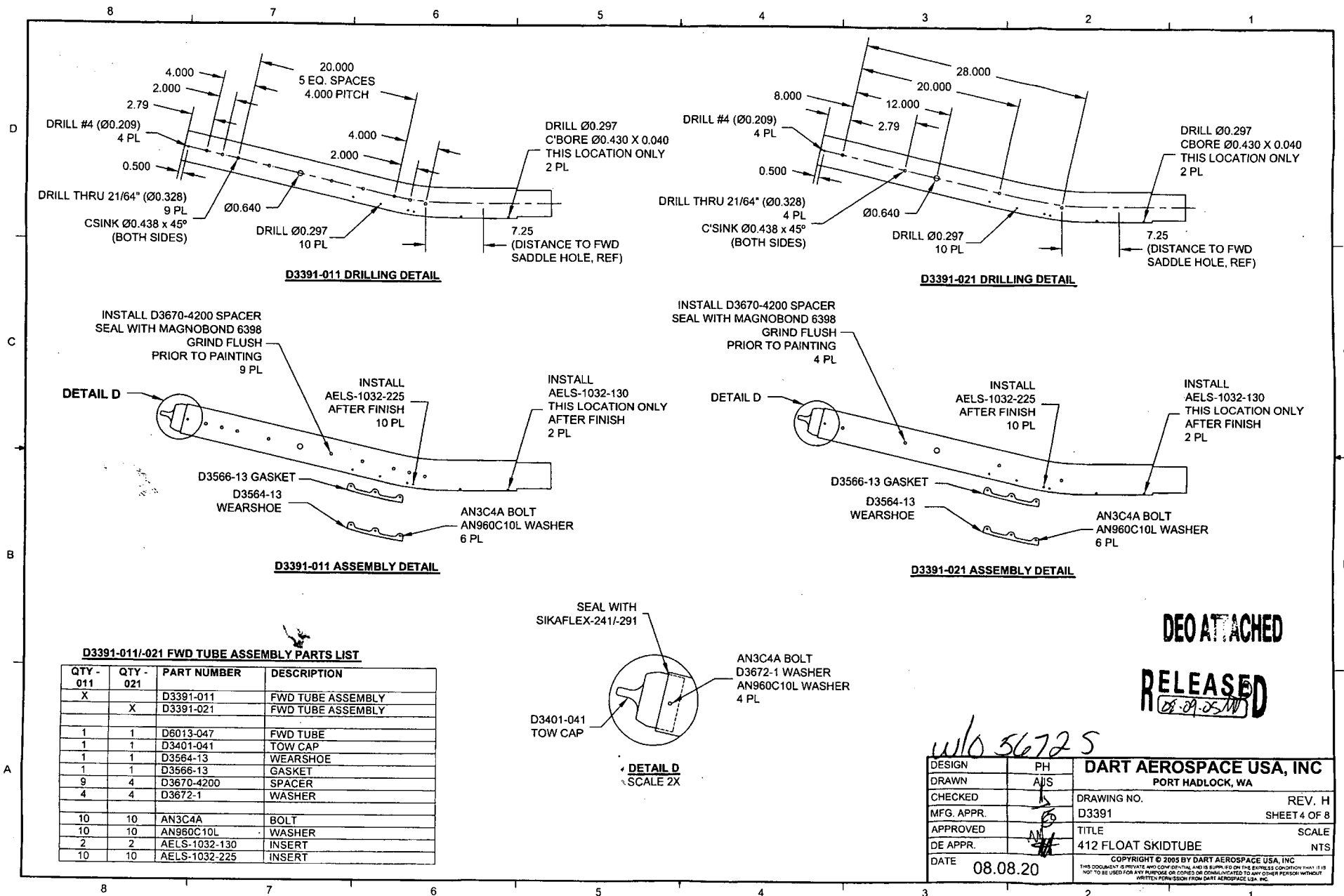


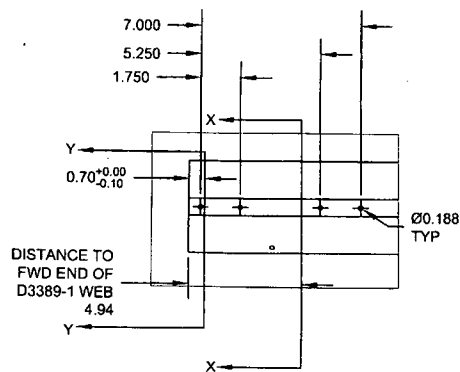
VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
08-05-11

W1056725

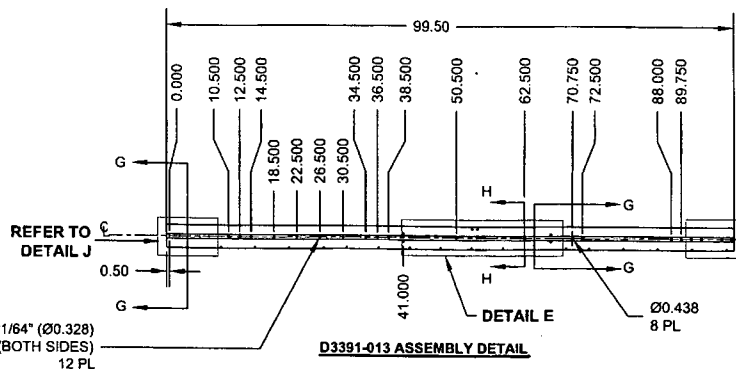
| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. D3391 | REV. H |
| MFG. APPR. | | | SHEET 3 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 412 FLOAT SKIDTUBE | NTS |
| DATE | 08.08.20 | <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |



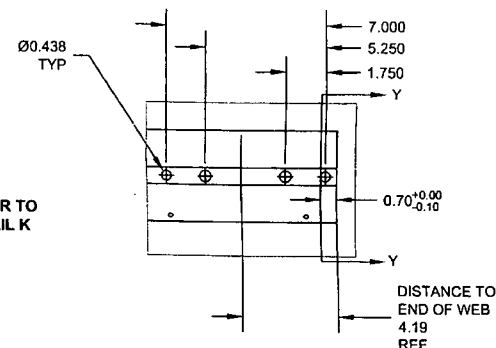


DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



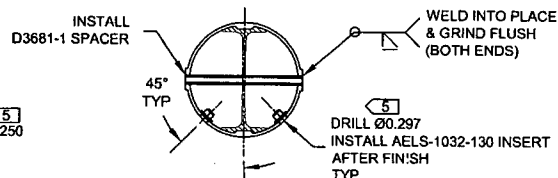
D3391-013 ASSEMBLY DETAIL



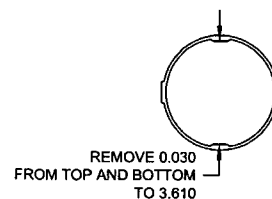
DETAIL K
SCALE 4X



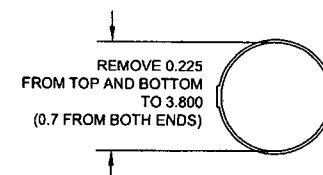
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



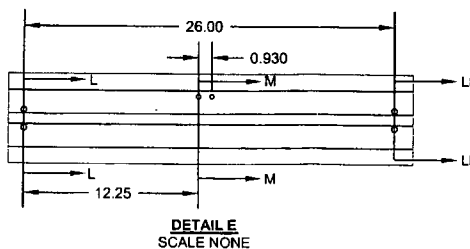
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER | DESCRIPTION |
|------|---------------|-------------------|
| -013 | | |
| X | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 4 | D3672-1 | WASHER |
| 4 | D3672-3 | WASHER |
| 12 | D3681-1 | SPACER |
| 24 | AELS-1032-130 | INSERT |
| 4 | ALS4-428-165 | INSERT |
| 4 | AN960C10L | WASHER |
| 4 | AN960C416L | WASHER |
| 4 | MS27039C1-09 | SCREW |
| 4 | MS27039C4-08 | SCREW |

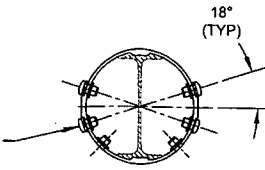
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

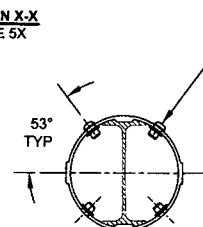


DETAIL E
SCALE NONE

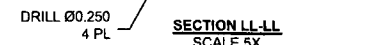
DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



SECTION L-L
SCALE 5X



SECTION M-M
SCALE 5X

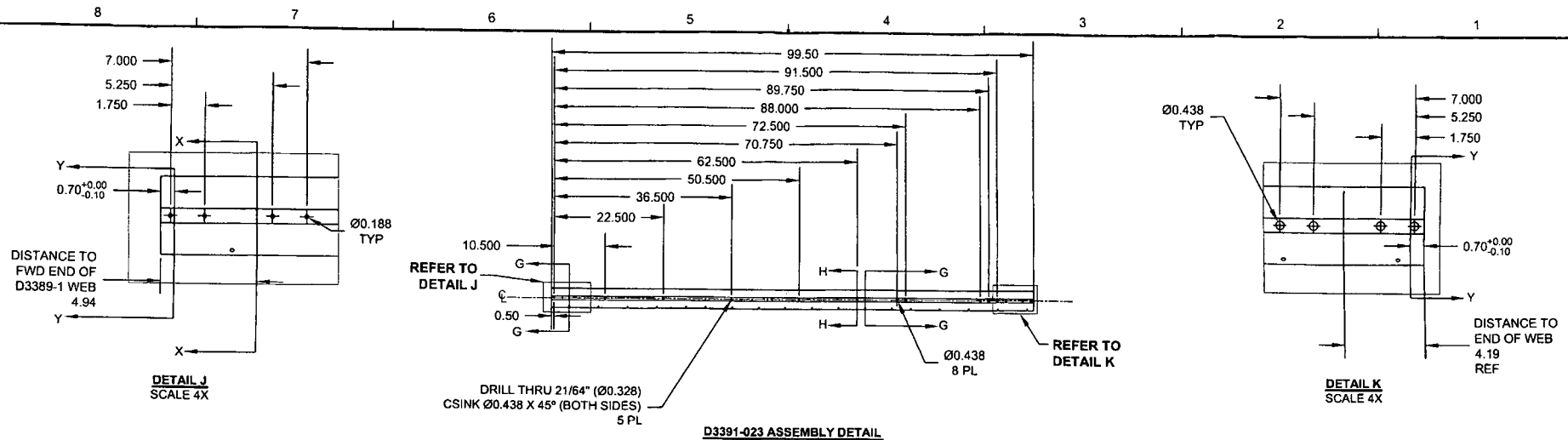


SECTION LL-LL
SCALE 5X

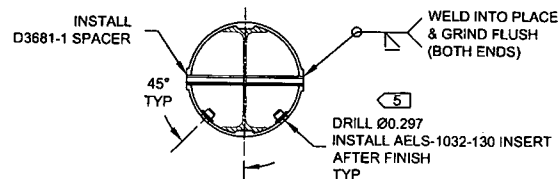
WLO 56725 DEO ATTACHED

RELEASED

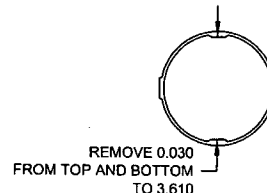
| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. H |
| MFG. APPR. | | D3391 | SHEET 5 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 412 FLOAT SKIDTUBE | NTS |
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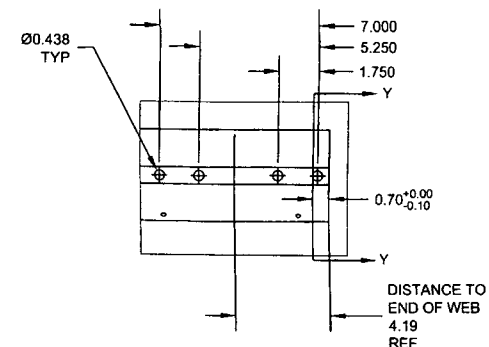
SECTION G-G
SCALE 5X



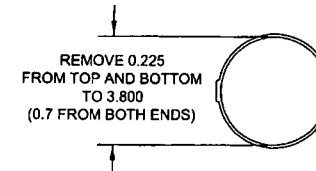
SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



DETAIL K
SCALE 4X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

| QTY - 023 | PART NUMBER | DESCRIPTION |
|-----------|---------------|-------------------|
| X | D3391-023 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 5 | D3681-1 | SPACER |
| 20 | AELS-1032-130 | INSERT |

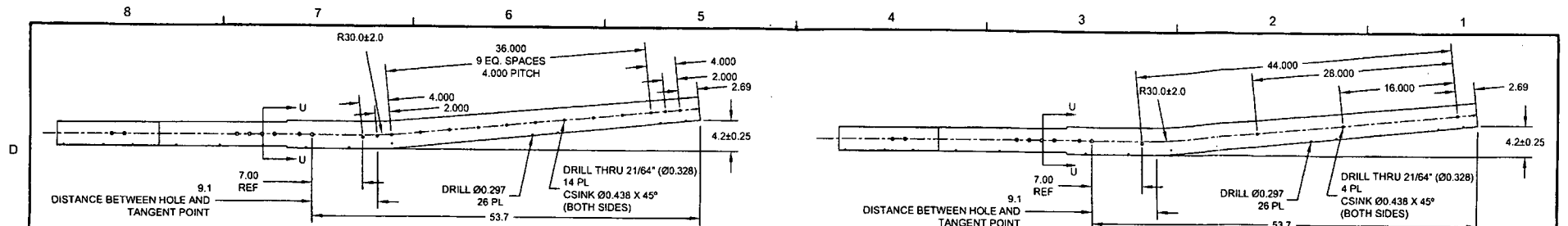
D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

| | | | | |
|------------|--|----------|--|--------------|
| DESIGN | | PH | DART AEROSPACE USA, INC | |
| DRAWN | | AS | PORT HADLOCK, WA | |
| CHECKED | | | DRAWING NO. | REV. H |
| MFG. APPR. | | | D3391 | SHEET 6 OF 8 |
| APPROVED | | | TITLE | SCALE |
| DE APPR. | | | 412 FLOAT SKIDTUBE | NTS |
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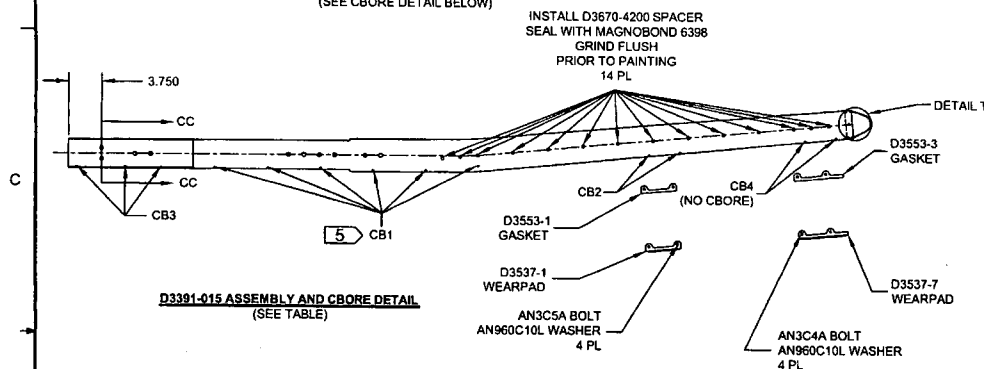
DEO ATTACHED
RELEASED
08-09-05-14

W/0 56725

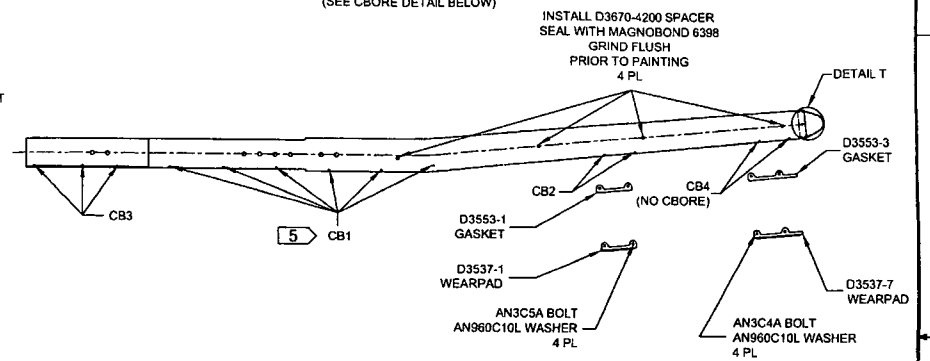


D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



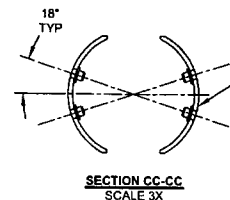
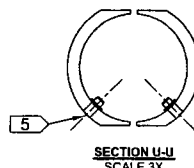
D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

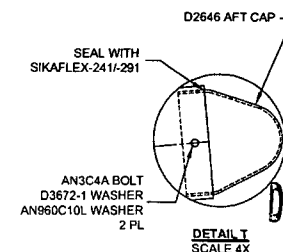
| QTY - 015 | QTY - 025 | PART NUMBER | DESCRIPTION |
|-----------|-----------|---------------|-------------------|
| X | X | D3391-015 | AFT TUBE ASSEMBLY |
| | | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | 1 | D6014-090 | AFT TUBE |
| 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-7 | WEARPAD |
| 1 | 1 | D3553-1 | GASKET |
| 1 | 1 | D3553-3 | GASKET |
| 14 | 4 | D3670-4200 | SPACER |
| 2 | 2 | D3672-1 | WASHER |
| 14 | 14 | AELS-1032-130 | INSERT |
| 12 | 12 | AELS-1032-225 | INSERT |
| 4 | | ALS4-428-165 | INSERT |
| 6 | 6 | AN3C4A | BOLT |
| 4 | 4 | AN3C5A | BOLT |
| 10 | 10 | AN960C10L | WASHER |

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | CBORE | P/N |
|--------------|---------------|---------------|----------------|---------------|
| CB1 | 12 | 12 | Ø0.430 X 0.170 | AELS-1032-225 |
| CB2 | 4 | 4 | Ø0.430 X 0.170 | AELS-1032-130 |
| CB3 | 6 | 6 | Ø0.430 X 0.040 | AELS-1032-130 |
| CB4 | 4 | 4 | NONE | AELS-1032-130 |



DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



DEO ATTACHED

RELEASED
08-09-05/10

| | | | |
|------------|----------|---|--------------|
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| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. H |
| MFG. APPR. | | D3391 | SHEET 8 OF 8 |
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| DE APPR. | | 412 FLOAT SKIDTUBE | NTS |
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| | | | | | | | |
|----------------------|-----------------------------|-------------------------|--|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3391 | TITLE 412 FLOAT SKIDTUBE | REV. H | DART AEROSPACE USA, INC ENGINEERING ORDER | | D.E.O. NO. D3391-H-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>CP</i> | CHECKED <i>h</i> | MFG. APPR. <i>AA</i> | APPROVED <i>MP</i> | | DE APPR. <i>h</i> | | |
| DATE 09.09.23 | DATE 04.04.24 | DATE 09/09/25 | DATE 09/09/30 | | DATE 09/09/30 | | |

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02
MP

W/056725

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